






3Plit

Sept-1

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:17:59 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y								
Job Number	: 28165 - A	Part Number	: D3443043								
Estimate Number	: 10678	Drawing Number	: D3443 REVB								
P.O. Number	: N/A	Project Number	: N/A								
This Issue	: 15/08/2006 S.O. No. : N/A	Drawing Revision	: B								
Prsht Rev.	: NC	Material	: N/A								
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 31/08/2006								
Previous Run	: 28069	Qty:	3 Um: Each								
Written By	: _____										
Checked & Approved By	: _____										
Comment	: EST. REV. A 05.11.17 NEW ISSUE EC										
Additional Product											
Job Number: 											
Seq. #:	Machine Or Operation:	Description :									
1.0	D34437	Tubing									
											
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3443-7</td> <td>TUBING</td> <td>B28233</td> </tr> </tbody> </table>				Qty	Part Number	Description	Batch	1	D3443-7	TUBING	B28233
Qty	Part Number	Description	Batch								
1	D3443-7	TUBING	B28233								
PD 06-09-07 (3)											
2.0	D34433	Clevis									
											
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3443-3</td> <td>CLEVIS</td> <td>B27795</td> </tr> </tbody> </table>				Qty	Part Number	Description	Batch	1	D3443-3	CLEVIS	B27795
Qty	Part Number	Description	Batch								
1	D3443-3	CLEVIS	B27795								
PD 06-09-07 (3)											
3.0	238805	SS DOWEL PIN 3/4" LONG									
											
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>238-805</td> <td>SS DOWEL PIN 3/4" LONG</td> <td>M19080</td> </tr> </tbody> </table>				Qty	Part Number	Description	Batch	1	238-805	SS DOWEL PIN 3/4" LONG	M19080
Qty	Part Number	Description	Batch								
1	238-805	SS DOWEL PIN 3/4" LONG	M19080								
PD 06-09-07 (3)											
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1									
											
Comment: LARGE FABRICATION RESOURCE 1 Weld assembly as per dwg D3443											
PD 06-09-07 (3)											

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:17:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 28165

Part Number: D3443043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

MD 06/09/08 (3)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL 0609 11 3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/09/11 (3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SB 06/09/11 (3)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SB 06/09/12

Job Completion



U 06-09-92

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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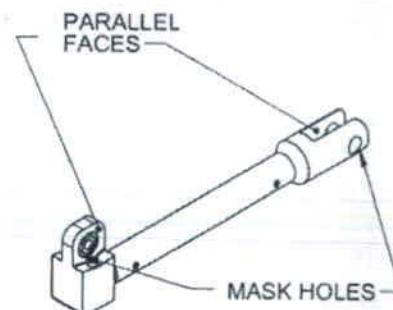
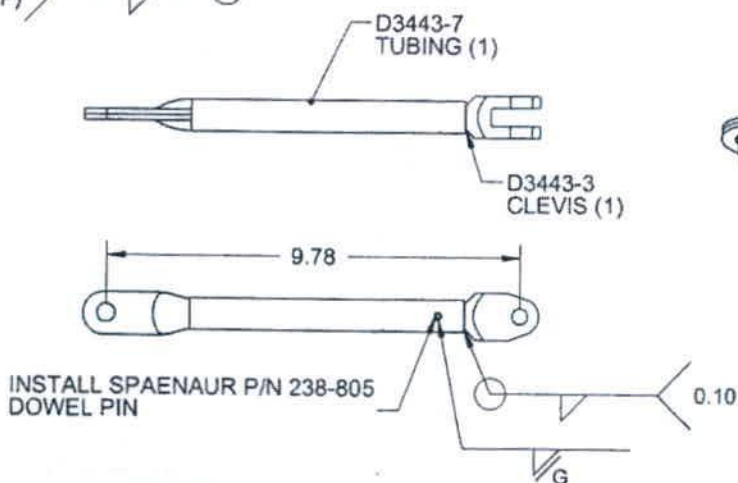
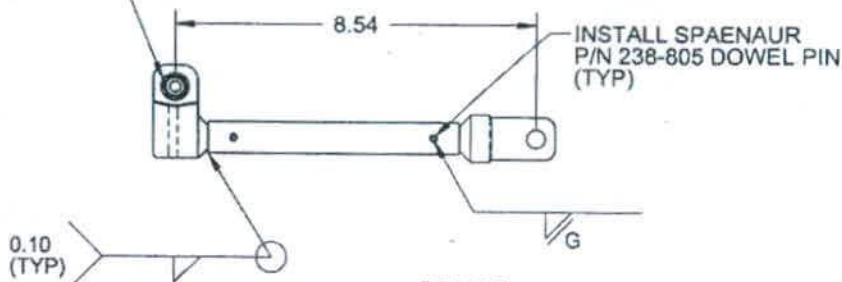
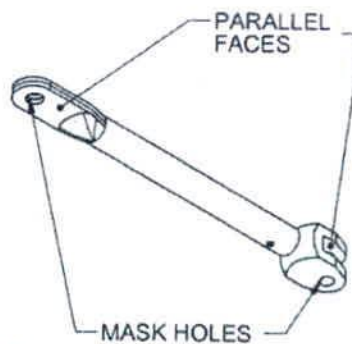
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED05.12.09 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

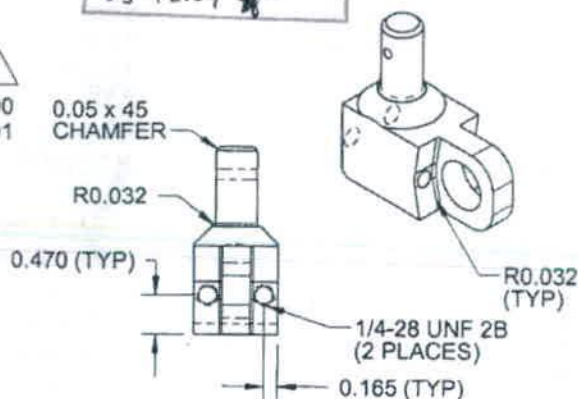
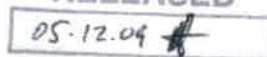
**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

REFERENCE ONLY

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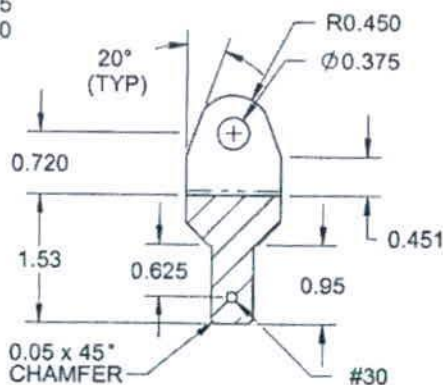
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D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

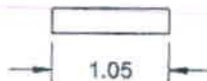
- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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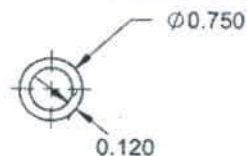
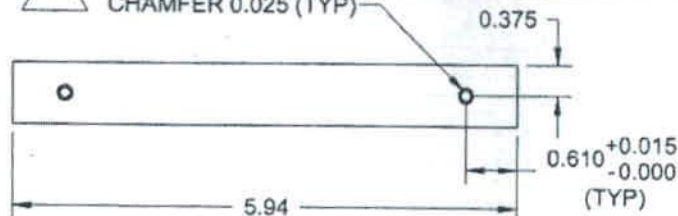
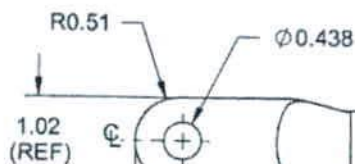
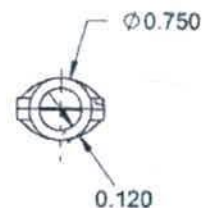
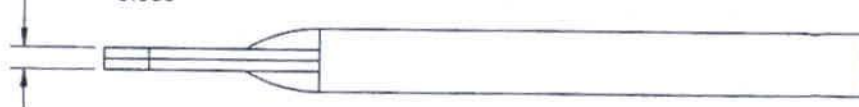
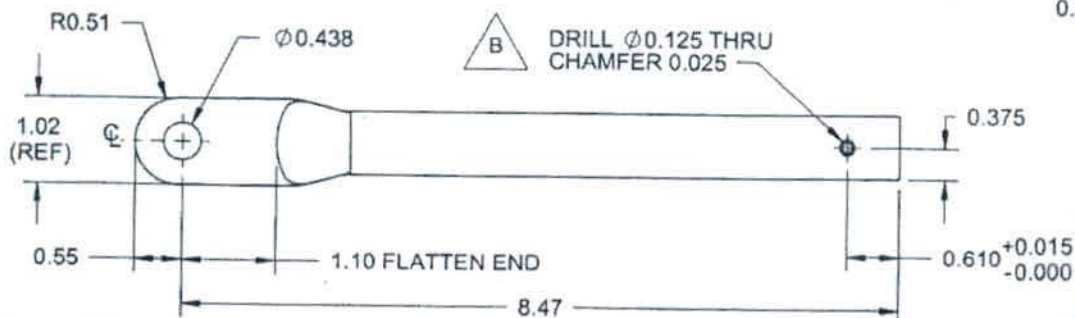
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2		

 $\varnothing 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED05.12.09 DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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